

Work Order ID 158439***158439***

Page 1

Wednesday, March 22, 2017 2:19:23 PM

Item ID: D2232-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Hinge

Start Date: 3/29/2017 Start Qty: 5.00

5

Cust Item ID:

Required Date: 4/3/2017 Req'd Qty: 5.00

5

Customer:

Reference: SCHEDULED

Approvals: Process Plan:

Date: MAR 22 2017 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2232

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.20

FLOW CNC Waterjet

1-Cut as per Dwg D2232 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary5 PR 17/03/25

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.05

Quality Control

5 PR 17/03/25

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.10

Quality Control

5DAS
38
9-89

MAR 27 2017

Work Order ID 158439

158439

Page 2

Wednesday, March 22, 2017 2:19:23 PM

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N900040100

Setup Start *NS1*

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Reference: SCHEDULED

Run Start *NR1*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

Small Fab

Memo
Debur

N/A DAS
38
9-88

0.00

0.19

140

140

Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

*****STOCK IN BASKET CELL*****
LOCATION : WA004

0.00

0.05

5 MAR 27 2017 6
9-88

150

150

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.50

17/3/2898

MA

MAR 28 2017

Picklist Print

Wednesday, March 22, 2017 2:19:29 PM

Page 1

Work Order ID: 158439

158439

Parent Item: D2232-3

D2232-3

Parent Item Name: Basket Hinge

Start Date: 3/29/2017

Required Date: 4/3/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP B01.06.07Now laser cutEC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased			No	100	sf	48.2700	0.0694	0.365263			

M304S11GA

304/316 0.125 Sheet

**

PR 17/03/25

Location

Loc Qty

Loc Code

MAT020

48.26998

M136687

16.26998

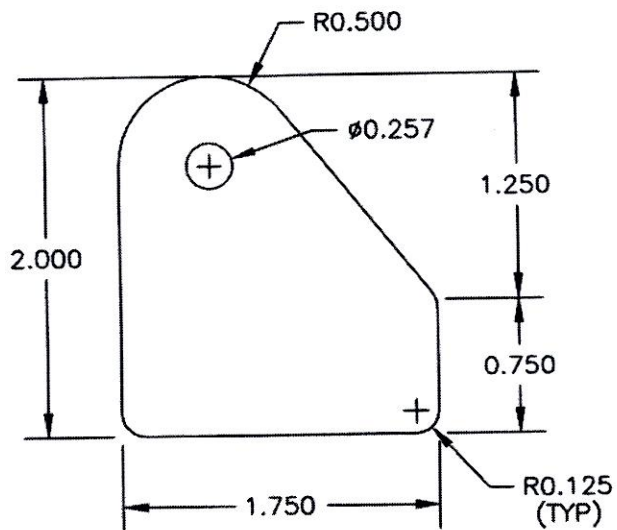
M137110

32

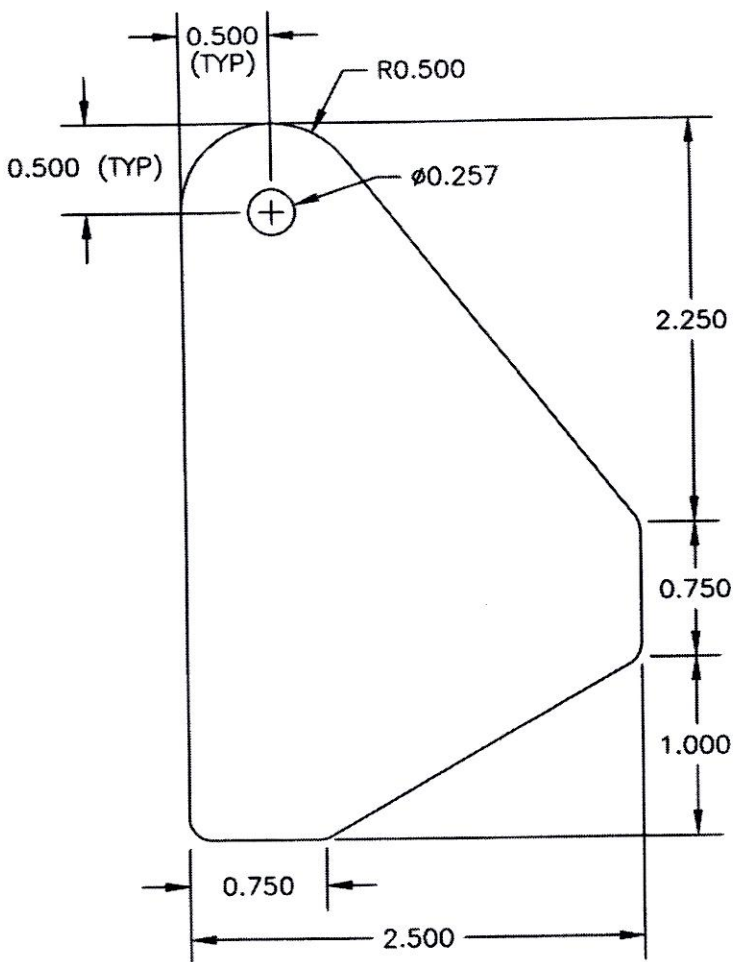
0.4

DART**RELEASED**
98.05.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAMKESBURY, ONTARIO, CANADA	REV. C
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2232	SHEET 1 OF 2
DATE 98.04.28		TITLE BASKET HINGE	SCALE 1:1
A	94.05.12	NEW ISSUE	
B	96.01.02	ADDED -5 AND -7	
C	98.04.28	0.125 THICK WAS 0.063	

D2232-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158439 MLJ
1703-22

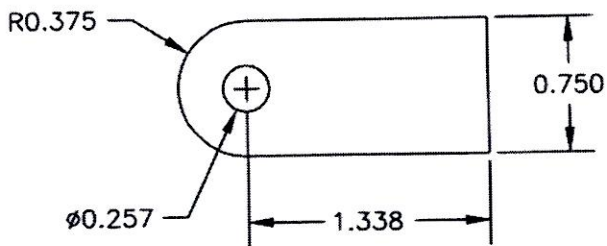
D2232-3

MATERIAL: AISI 304/316 SS 0.125 THICK

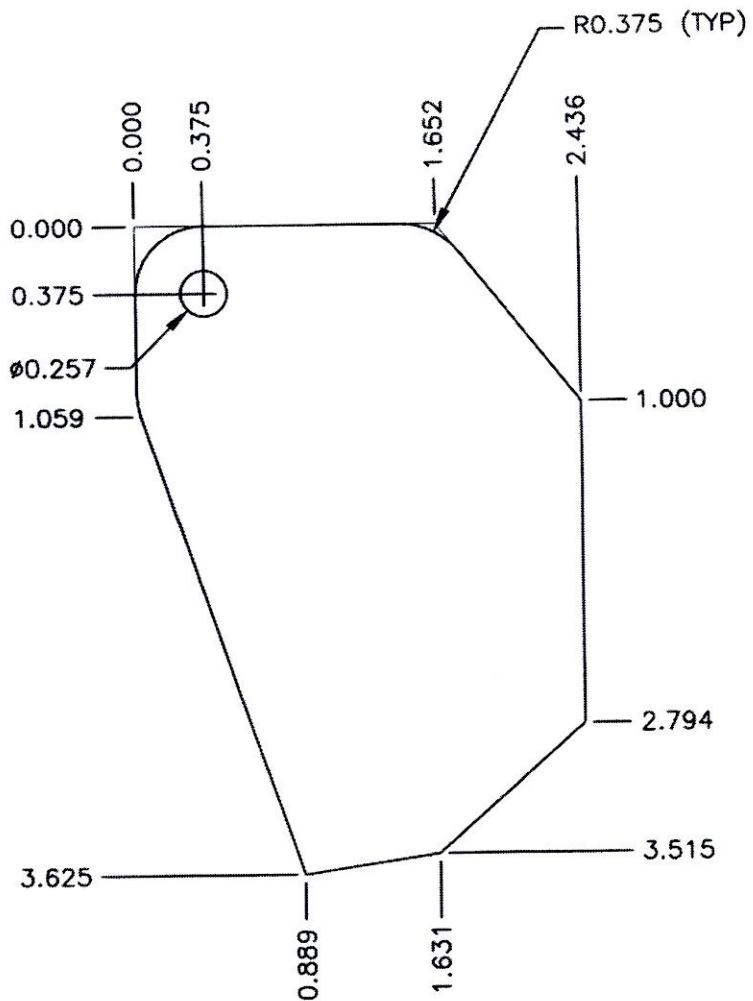
QA COPY ISSUED

DESIGN		DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. C
				D2232	SHEET 2 OF 2
DATE				TITLE	SCALE
98.04.28				BASKET HINGE	1:1

RELEASED
98.05.05 KE



D2232-7



D2232-5

MATERIAL: AISI 304/316 SS 0.125 THICK